

Work Order ID 81826

81826

Page 1

Monday, March 19, 2012 4:04:33 PM

Item ID: D135-692-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 3/19/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/21/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference: ECN12-550 - REWORK

Approvals: Process Plan: MS Date: 12-03-19 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3049	Rev A1

190 0.00

190

Packaging Memo 0.00
 Packaging PULL FROM STOCK D135-692-011 X 2 B73966

REMOVE AN4-15A B119749 X 8 PER KIT AND RETURN TO STOCK
 UNDER ORIGINAL BATCH NUMBER

REPLACE WITH AN4-13A X 8 B PER KIT
 PER ECN 12-550 (DSI 9587)

REMOVE 4 X D2519 B65118 PER KIT AND RETURN TO STOCK UNDER
 ORINAL BATCH NUMBER
 PER ECN 12-550 (DSI 9592)

200 QC4- 100% Inspect kits for completeness 0.00

200

QC Memo 0.00
 Quality Control

1119749

12/3/22

5, 2/3/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81826***81826***

Page 2

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Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 3/19/2012 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/21/2012 Req'd Qty: 2.00 ***2*** Customer:
Reference: ECN12-550

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>11A</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging	ID AND STOCK UNDER NEW BATCH NUMBER								
	ADD NEW DSI'S TO PAPERWORK								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

CHG002

12/3/27 5 f (24)

MLJ 12/03/27

12-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 19, 2012 4:04:32 PM

Page 1

Work Order ID: 81826

Parent Item: D135-692-011

Parent Item Name: Bearpaw

Start Date: 3/19/2012

Required Date: 3/21/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step 3KJ/JLM
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A Bolt		Purchased	No				Each	1,357.0000		51 16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST357		1357							
				119449		59							
				120187		398				10			
				120422		500							
				120770		400							
AN4-15A Bolt		Purchased	No				Each	359.0000		11949 ¹⁶			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		100							
				120449		100							
				ST358		259							
				118706		15							
				120187		44							
				120422		200							
D2519 Clamp		Manufactured	No				Each	28.0000		765118 ⁸ 54			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST459		28							
				73499		28							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D135-692 REV. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-692 REV. 0
REF. FAA STC: SR01042SE

PURPOSE:

The purpose of this service instruction is to replace the AN4-15A Bolt with a shorter AN4-13A Bolt to facilitate installation.

CHANGE:

5. PARTS LIST (IIN-D135-692)
32.4 PARTS LIST (ICA-D135-692)

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION

IS:

8	AN4-13A	BOLT
---	---------	------

WAS:

8	AN4-15A	BOLT
---	---------	------

Figure 2 of IIN-D135-692 and Figure 32-2 of ICA-D135-692 are amended as follows:

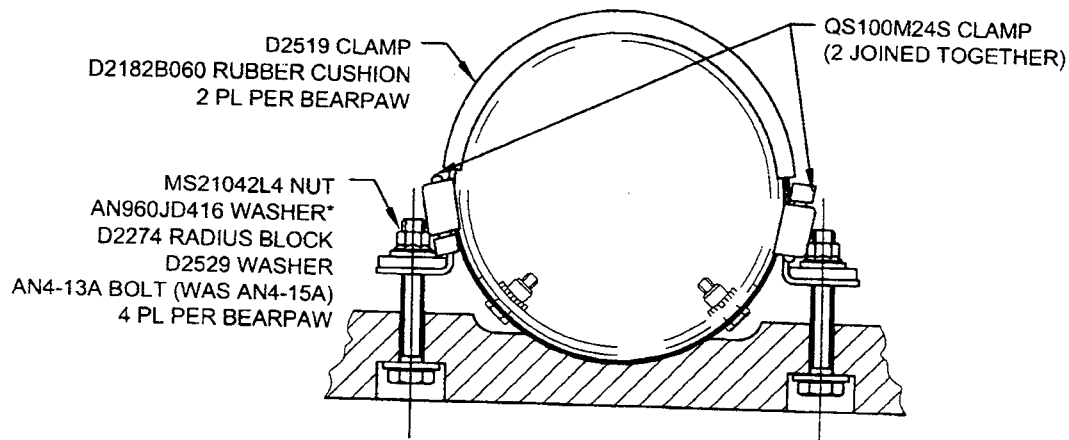


Figure 2 - Bearpaw Installation (IIN-D135-692)
Figure 32-2: Bearpaw Installation (ICA-D135-692)

A	NEW ISSUE	(REF: PAR10-56)	MB	11.12.13
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC KENT, WA		REV. A	
DRAWN			SHEET 1 OF 1	
CHECKED	DRAWING NO.	SCALE		
MFG. APPR.	DSI 9587	NTS		
APPROVED	TITLE	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC		
DE APPR.	BOLT CHANGE	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		
DATE	11.12.13			

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-692 REV. 0

REF. FAA STC: SR01042SE

REF. TCCA LETTER OF ACCEPTANCE: 120S-GA-08-52

REF. UK STC: AAN #28700

PURPOSE:

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO CORRECT A DISCREPANCY IN SECTION 32.4 OF ICA-D135-692 REV. 0.

CHANGE:

FOR D135-692-011 BEARPAW INSTALLATION, THE D2519 CLAMP QTY(8) SHOWN IN THE PARTS LISTS IS UPDATED AS INDICATED BELOW:

32.4 PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION

IS:

4	D2519	CLAMP
---	-------	-------

WAS:

8	D2519	CLAMP
---	-------	-------

48824

A	NEW ISSUE	(REF CAR11-60)	MB	12.01.18
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC		
DRAWN		KENT, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		DSI 9592	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		PARTS LIST CORRECTION	NTS	
DATE	12.01.18	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

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Tuesday, September 20, 2011 10:19:56 AM

Page 1

Work Order ID: 73966

Parent Item: D135-692-011

Parent Item Name: Bearpaw



Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17 Blank size changed, Tolerance added Step 3 KJ/JLM
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A

Purchased

No

160

Each

471.0000

8

16

119749

Handwritten signature

Bolt

Location

Loc Qty

Loc Code

ST358

471

118112

4

118648

267

118706

200

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

0.0000

8

16

119078

Handwritten signature

Washer

D2182B

Manufactured

No

160

f

73.5212

2

4

73932

Handwritten signature

Rubber Cushion

Location

Loc Qty

Loc Code

ST410

73.52117

66063

73.52117

(D2182B060) Cut 4 at 6.00"

D2274

Manufactured

No

160

Each

644.0000

8

16

74438

Handwritten signature

Radius Block

Location

Loc Qty

Loc Code

ST010

243

69736

9

73389

234

ST011

401

72121

401

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:19:56 AM

Page 2

Work Order ID: 73966

Parent Item: D135-692-011

Parent Item Name: Bearpaw

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

D2519

Manufactured No

160 Each

25.0000

4 8



Clamp

Location

Loc Qty

Loc Code

ST462

25

65118

25

160

Each

647.0000

8

65118

16

76086

D2529

Manufactured No

160

Each

647.0000

8



Washer

Location

Loc Qty

Loc Code

ST016

647

71161

250

73486

397

160

Each

0.0000

2

4

D3049-1

Manufactured No

160

Each

0.0000

2

4



Bearpaw

73965

11/12/12

MS21042L4

Purchased No

160

Each

4,309.000

8

16



Nut

119017

11/12/12 (2)

Location

Loc Qty

Loc Code

ST300

4309

117441

51

117601

637

117885

621

118451

2000

118927

1000

Tuesday, September 20, 2011 10:19:56 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 12.03.16	Job No.:	ADR Yes/No: Y	ADR Date: 11.03.15	ECN #: 12- 550
Product No.: D135-692		Created By: CP	Approved By: <i>[Signature]</i>	
Product Name: Bearpaw		Checked By: <i>[Signature]</i>		

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL	
Purchasing Coord.	N		
Production Engineering Coord.	Y	EC/DD	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	N		
QC Coordinator	<i>[Signature]</i> Y	ED.	
Customer Technical Support	Y	MB	
Marketing	Y	SW	
Customer Order Processing	N		

Reason for Change:

Documents Affected:

Release

DSI 9537 Rev. B

DSI 9587 Rev. A

DSI 9592 Rev. A

PARTS MUST COMPLY



PREVIOUS PARTS SATISFACTORY



#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	MB		
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	Y	CP		12.03.19 <i>[Signature]</i>
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.03.19 <i>[Signature]</i>
11	Update Product Specification Files	Y	KJ		12.03.19 <i>[Signature]</i>
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.03.19 <i>[Signature]</i>
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update PPP's	N			
20	Red Decals required?	N			
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		12.03.19 <i>[Signature]</i>
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		12.03.19 <i>[Signature]</i>
24					

Description / Action:

- Per DSI 9592, there should only be (4) D2519 Clamps in a D135-692-011 kit
- Per DSI 9587, replace (8) AN4-15A with (8) AN4-13A bolts in D135-692-011, update kits in stock
- add DSI's to kits in stock

6 Kits in stock
2 x 73966 : Rework #81826
4 x 78385 : Rework #81827

ECN Verified & Complete: _____

Date: _____